

WHAT IS CLAIMED IS:

1. A method for placing a product in a flexible recloseable container, comprising:
providing a pair of interlockable fastener strips, a web of flexible film, and a plurality of sliders;
feeding the pair of interlockable fastener strips;
placing the plurality of sliders on the pair of interlockable fastener strips;
feeding the web of flexible film;
attaching the interlockable fastener strips to the web of flexible film after said placing the plurality of sliders; and
placing a product within the web.
2. The method according to claim 1 which further comprises repositioning a slider before said placing a product.
3. The method according to claim 1 wherein said fastener strips include a tamper evident seal.
4. The method according to claim 1 which further comprises stopping the pair of interlockable fastener strips before placing each of the plurality of sliders.
5. The method according to claim 1 wherein said feeding the pair of interlockable fastener strips is continuous during said placing the plurality of sliders.
6. The method according to claim 1 which further comprises stopping the web before said attaching the interlockable fastener strips.

7. The method according to claim 1 wherein said feeding the web is continuous during said attaching the interlockable fastener strips.
8. The method according to claim 1 wherein during said feeding the pair of fastener strips the fastener strips are interlocked, and which further comprises unlocking a portion of the pair of fastener strips before placing each of the plurality of sliders.
9. The method according to claim 1 which further comprises opening the web of flexible film by cutting the film before said placing a product.
10. The method according to claim 9 which further comprises resealing the web after said placing a product.
11. The method according to claim 1 wherein during said feeding the web, the web is in a substantially horizontal orientation.
12. The method according to claim 1 which further comprises before said attaching creating a plurality of docking stations on at least one of the pair of interlockable fastener strips, each docking station being positioned between adjacent sliders.
13. The method according to claim 12 wherein said creating a plurality of docking stations is by slitting a portion of at least one of the interlockable fastener strips for each docking station.
14. The method according to claim 12 wherein said creating a plurality of docking stations is by cutting a notch from at least one of the interlockable fastener strips for each docking station.

15. The method according to claim 12 wherein said creating a plurality of docking stations is by fusing a portion of the interlocked pair of fastener strips and positioning a slider into the heat affected zone for each docking station.
16. The method according to claim 1 which further comprises cutting a plurality of notches along at least one of the interlockable fastener strips before said attaching, each notch being between adjacent sliders.
17. The method according to claim 1 which further comprises before said attaching placing a plurality of endstops on the interlocked pair of fastener strips, each endstop being positioned between adjacent sliders.
18. The method according to claim 17 wherein said placing a plurality of endstops is by fusing a plurality of portions of the interlocked pair of fastener strips.
19. The method according to claim 17 wherein said placing a plurality of endstops is by clamping portions of the interlocked pair of fastener strips with a plurality of clamps.
20. The method according to claim 1 wherein said providing a pair of interlockable fastener strips is from an extruding apparatus.
21. An apparatus comprising:
a first fastener strip having an inner surface and at least one first closure element positioned along the length of the inner surface;
a second fastener strip having an inner surface and at least one second closure element positioned along the length of the inner surface, the at least one said second

closure element being adapted to repeatedly lock together with and repeatedly unlock from the at least one said first closure element; and

a plurality of sliders in straddling relation to said first fastener strip and said second fastener strip, said sliders being adapted and configured for repeatedly locking and repeatedly unlocking the at least one said first closure element and the at least one said second closure element by sliding movement thereon;

wherein said apparatus is separable from a flexible web but capable of being attached to a flexible web to form a plurality of recloseable containers.

22. The apparatus of claim 21 which further comprises a plurality of endstops for limiting the sliding of said sliders, said endstops and said sliders being arranged along said first fastener strip and said second fastener strip in an alternating manner.

23. The apparatus of claim 22 wherein said plurality of endstops are sections of said first fastener strip fused to sections of said second fastener strip.

24. The apparatus of claim 22 wherein said plurality of endstops are clamps which clamp sections of said first fastener strip to sections of said second fastener strip.

25. The apparatus of claim 21 wherein said first fastener strip has a length and includes a plurality of position marks for establishing the sizes of the recloseable containers.

26. The apparatus of claim 21 wherein said first fastener strip includes a first projecting portion proximate the first closure element and extending upwardly therefrom, said second fastener strip includes a second projecting portion proximate the second closure element and extending upwardly therefrom, said first portion facing said second portion when said first closure element and said second closure element are locked

together, said first portion or said second portion defining a plurality of notches therethrough, said notches of said first portion or said second portion being adapted and configured for docking a slider therein.

27. The apparatus of claim 26 wherein each of said first portion and said second portion define a plurality of notches therethrough, each said notch of said first portion being generally aligned with one said notch of said second portion when said first closure element and said second closure element are interlocked.

28. The apparatus of claim 21 which further comprises a tamper evident seal coupled to first fastener strip and said second fastener strip.

29. The apparatus of claim 21 wherein said first fastener strip includes a first projecting portion proximate the first closure element and extending upwardly therefrom, said second fastener strip includes a second projecting portion proximate the second closure element and extending upwardly therefrom, said first portion facing said second portion when said first closure element and said second closure element are locked together, said first fastener strip or said second fastener strip having a plurality of docking stations thereon, each said docking station comprising at least one slit, the slits through said first portion or through said second portion cooperating to form a plurality of docking stations for said sliders.

30. The apparatus of claim 21 wherein said first fastener strip includes a first plurality of closure elements, and said second fastener strip includes a second plurality of closure elements.

31. The apparatus of claim 21 wherein said first fastener strip includes a first spacing element for spacing apart said first fastener strip from said second fastener strip, and said second fastener strip includes a second spacing element for spacing apart said first fastener strip from said second fastener strip.
32. A method for placing a product in a flexible recloseable container, comprising:
feeding a web of flexible film with interlockable fastener strips;
orienting a slider to a predetermined orientation;
stopping the web of flexible film;
placing the slider over the fastener strips during said stopping;
moving the slider relative to the fastener strips such that the fastener strips are generally closed; and
placing a product within the web.
33. The method of claim 32 which further comprises forming a transverse seal generally across the film.
34. The method of claim 32 which further comprises spreading apart the feet of the slider before said placing the slider.
35. The method of claim 32 which further comprises spreading apart at least one closure element of the fastener strips before said placing the slider.
36. The method of claim 32 wherein said feeding includes forming the web in a generally tubular shape.

37. The method of claim 36 wherein during said placing of the product the container is in a substantially vertical orientation.
38. The method of claim 32 wherein said feeding includes forming the web in a generally folded shape.
39. The method of claim 38 wherein during said placing of the product the container is in a substantially vertical orientation.
40. The method of claim 38 wherein during said placing of the product the container is in a substantially horizontal orientation.
41. The method of claim 32 which further comprises placing a tamper evident seal on the container.
42. A method for placing a product in a flexible recloseable container, comprising:
feeding a web of flexible film with interlocked fastener strips;
orienting a slider to a predetermined orientation;
spreading apart the feet of the slider;
unlocking the fastener strips;
placing the slider over the fastener strips;
interlocking the fastener strips; and
placing a product within the web.
43. The method of claim 42 which further comprises stopping the web of flexible film before said placing the slider.

44. The method of claim 42 which further comprises spreading apart at least one closure element of the fastener strips before said placing the slider.
45. The method of claim 42 wherein said feeding includes forming the web in a generally tubular shape.
46. The method of claim 45 wherein during said placing of the product the container is in a substantially vertical orientation.
47. The method of claim 42 wherein said feeding includes forming the web in a generally folded shape.
48. The method of claim 47 wherein during said placing of the product the container is in a substantially vertical orientation.
49. The method of claim 47 wherein during said placing of the product the container is in a substantially horizontal orientation.
50. The method of claim 42 which further comprises placing a tamper evident seal on the container.
51. An apparatus for placing a product in a flexible recloseable container, comprising:
means for feeding a web of flexible film with interlocked fastener strips;
a slider for locking and unlocking the fastener strips, said slider having feet;
a slider application machine for placing said slider on the fastener strips, said slider application machine including a rotatable selector wheel and a spreading ridge, said wheel including a pocket for accepting said slider and moving said slider while said slider is in contact

with said spreading ridge such that the feet are spread apart sufficiently to pass over the shoulders; and

means for placing a product within the web of flexible film;

wherein said interlocked fastener strips are unlocked before said sliders are placed on said unlocked fastener strips.

52. The apparatus of claim 51 which further comprises means for moving the slider relative to the fastener strips such that the fastener strips are generally closed.

53. The apparatus of claim 51 which further comprises a guide for orienting the fastener strips to accept said slider from the pocket.

54. The apparatus of claim 51 wherein said means for feeding stops the web when said selector wheel rotates to place said slider on the fastener strips.

55. The apparatus of claim 51 wherein said means for feeding forms the flexible film into a generally tubular shape.

56. The apparatus of claim 55 wherein said means for placing places the product within the web in a generally vertical manner.

57. The apparatus of claim 51 wherein said means for feeding forms the flexible film into a generally folded shape.

58. The apparatus of claim 57 wherein said means for placing places the product within the web in a substantially vertical orientation.

59. The apparatus of claim 57 wherein said means for placing places the product within the web in a substantially horizontal orientation.
60. The apparatus of claim 51 which further comprises a probe for unlocking said interlocked fastener strips.
61. The method of claim 32 wherein said fastener strips include two pairs of closure elements, and wherein during said feeding each of the two pairs of closure elements are interlocked.
62. The method of claim 61 which further comprises unlocking only one pair of closure elements prior to said placing the slider.
63. The method of claim 42 which further comprises stopping the web of flexible film, and wherein said placing the slider over the fastener strips is during said stopping.
64. The method of claim 42 wherein said fastener strips include two pairs of interlocked closure elements and wherein during said unlocking only one pair of closure elements are unlocked.
65. A method for manufacturing a flexible recloseable container, comprising:
providing a pair of interlockable fastener strips, a web of flexible film, and a plurality of sliders;
feeding the pair of interlockable fastener strips;
placing the plurality of sliders on the pair of interlockable fastener strips;
feeding the web of flexible film; and

attaching the interlockable fastener strips to the web of flexible film after said placing the plurality of sliders.

66. The method according to claim 65 which further comprises repositioning each slider after said attaching.

67. The method according to claim 65 which further comprises spreading apart the feet of a slider during said placing the plurality of sliders.

68. The method according to claim 65 which further comprises stopping the pair of interlockable fastener strips before placing each of the plurality of sliders.

69. The method according to claim 65 wherein said feeding the pair of interlockable fastener strips is continuous during said placing the plurality of sliders.

70. The method according to claim 65 which further comprises stopping the web before said attaching the interlockable fastener strips.

71. The method according to claim 65 wherein said feeding the web is continuous during said attaching the interlockable fastener strips.

72. The method according to claim 65 wherein during said feeding the pair of fastener strips the fastener strips are interlocked, and which further comprises unlocking a portion of the pair of fastener strips before placing each of the plurality of sliders.

73. The method according to claim 65 wherein during said feeding the web, the web is in a substantially horizontal orientation.

74. The method according to claim 65 which further comprises before said attaching creating a plurality of docking stations on at least one of the pair of interlockable fastener strips, each docking station being positioned between adjacent sliders.

75. The method according to claim 74 wherein said creating a plurality of docking station is by slitting a plurality of portions of at least one of the interlockable fastener strips.

76. The method according to claim 74 wherein said creating a plurality of docking station is by cutting a plurality of notches from at least one of the interlockable fastener strips.

77. The method according to claim 74 wherein said creating a plurality of docking station is by fusing a portion of the interlocked pair of fastener strips and positioning a slider into the heat affected zone for each docking station.

78. The method according to claim 65 which further comprises cutting a plurality of notches along at least one of the interlockable fastener strips before said attaching, each notch being positioned between adjacent sliders.

79. The method according to claim 65 which further comprises before said attaching placing a plurality of endstops on the interlocked pair of fastener strips, each endstop being positioned between adjacent sliders.

80. The method according to claim 79 wherein said placing a plurality of endstops is by fusing a plurality of portions of the interlocked pair of fastener strips.

81. The method according to claim 79 wherein said placing a plurality of endstops is by clamping portions of the interlocked pair of fastener strips with a plurality of clamps.

82. The method according to claim 65 wherein said providing a pair of interlockable fastener strips is from an extruding apparatus.

83. The method according to claim 65 wherein the fastener strips include a plurality of position marks, and wherein said placing the plurality of sliders is in relation to the plurality of position marks, each slider being between adjacent position marks.